

Date: Monday, 02/06/2008 1:54:23 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: TUBE ASSEMBLY	
Job Number	: 39644		Part Number	: D2003043	
Estimate Number	: 10923		Drawing Number	: UNDER REVIEW	
P.O. Number	:		Project Number	: N/A	
This Issue	: 02/06/2008 S.O. No. :		Drawing Revision	: B	
Prsht Rev.	: NC		Material	:	
First Issue	: / /		Due Date	: 03/06/2008	
Previous Run	: 37325		Qty:	5 Um: Each	
Written By	:				
Checked & Approved By	: JLD 08.6.02				
Comment	: Est. B 00.01.12 Re-format EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL type labels per PPP D2003-043	JLD 8.6.13
2.0	M304TR0500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 0.9406 f(s)/Unit Total : 4.7030 f(s) Material: 1/2" x 0.035" wall AISI 304 SS tubing	Batch: M108215 FF 08-06-12 (5)
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Form tube as per template D2003-043	FF 08-06-02 (5)
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	S 08/06/12 (X5)
5.0	M26506	Firesleeve-crkl .375IDia	
		Comment: Qty.: 1.0238 f(s)/Unit Total : 5.1188 f(s) Material: M2650-6 Heat sleeve	Batch: M107746 FF 08-06-12 (5)
6.0	MS20819J	Sleeve	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Pick: Qty Part Number Description Batch	M107959 FF 08-06-12 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 39644

Part Number: D2003043

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0 AN8188J

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN818-8J	Nut	M107959

FF 02-06-12

(5)

8.0 D2182

Heat Shrink



Comment: Qty.: 0.3750 f(s)/Unit Total : 1.8750 f(s)

Pick:

Qty	Part Number	Description	Batch
1	D2182-045	Heat shrink	B17067

FF 02-06-12

5

9.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut as per template D2003-043 (10.75" long)
2-Cut: 11.7" long as per Dwg D2003
3-Assemble as per Dwg D2003

CONFIRM W/ENG. CUT LENGTH
OF TUBING

08-06-02

FF 02-06-13

(5)

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

808/06/13 (X5)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 5

8/4/13

(X5)
SP

12.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/16 (X5)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



8/06/13

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE		D2003	SHEET 1 OF 2
99.06.08		TITLE 206 CABIN HEATER TUBE ASSEMBLIES NTS	
A	90.04.09	NEW ISSUE	
B	99.06.08	UPDATE PER TEMPLATES; ADD P/N'S; 0.025 TUBING NOW 0.035 (TSR1049)	

RELEASED
49.06.08 KG

UNDER REVIEW

SL.08.21 LB Some flat
parts wrong

106.06.02

P/N	TEMPLATE	HEATSLEEVE LENGTH ¹	CUT LENGTH OF TUBE ²	MATERIAL ^{4/8/7}				VENDOR OR SPEC
				MS20819-8J SLEEVE	AN818-8J NUT	MS20819-8D SLEEVE	AN818-8D NUT	
D2003-001	T2003-001	5.2	6.00			2	2	TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W
D2003-003	T2003-003	7.3	8.12			2	2	TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W
D2003-005	T2003-005	9.8	10.62			2	2	TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W
D2003-007	T2003-007	20.0	19.63			2	2	TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W
D2003-009	T2003-009	12.38	12.44			2	2	TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W
D2003-011	T2003-011	33.31	32.38			2	2	TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W
D2003-013	T2003-013	12.7	13.54			2	2	TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W
D2003-015	T2003-015	17.2	18.00			2	2	TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W
D2003-017	T2003-017	17.0	16.25			2	2	TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W
D2003-019	T2003-019	9.8	10.62	2	2			TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W
D2003-021	T2003-021	N/A	2.25	2	2			TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W
D2003-023	T2003-023	4.5	5.33	2	2			TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W
D2003-025	T2003-025	9.8	10.60	2	2			TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W
D2003-027	T2003-027	7.25	7.38	2	2			TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W
D2003-029	T2003-029	17.2	18.00	2	2			TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W
D2003-031	T2003-031	14.6	15.38	2	2			TUBE ASS'Y CRES 0.500 OD x 0.035 W
D2003-033	T2003-033	29.75	29.62	2	2			TUBE ASS'Y CRES 0.500 OD x 0.035 W
D2003-035	T2003-035	24.7	27.00	2	2			TUBE ASS'Y CRES 0.500 OD x 0.035 W
D2003-037	T2003-037	24.81	23.38	2	2			TUBE ASS'Y CRES 0.500 OD x 0.035 W
D2003-039	T2003-039	34.0	34.00	2	2			TUBE ASS'Y CRES 0.500 OD x 0.035 W
D2003-041	T2003-041	6.0	5.88	2	2			TUBE ASS'Y CRES 0.500 OD x 0.035 W
D2003-043	T2003-043	11.7	10.75	2	2	6.06-17		TUBE ASS'Y CRES 0.500 OD x 0.035 W
D2003-045	T2003-045	3.50	2.44	2	2			TUBE ASS'Y CRES 0.500 OD x 0.035 W
D2003-047	T2003-047	5.56	5.56	2	2			TUBE ASS'Y CRES 0.500 OD x 0.035 W
D2003-049	T2003-049	33.2	34.00	2	2			TUBE ASS'Y CRES 0.500 OD x 0.035 W
D2003-077	T2003-077	N/A	6.25			1	1	JET 6061-T6 0.375 OD x 0.035 W
D2003-101	T2003-101	13.25	13.13			2	2	TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W
D2003-103	T2003-103	12.38	12.00			2	2	TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W
D2003-105	T2003-105	10.75	10.60			2	2	TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W
D2003-107	T2003-107	12.75	12.25			2	2	TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W
D2003-109	T2003-109	8.25	8.125	2	2			TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W
D2003-111	T2003-111	4.75	4.625	2	2			TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W
D2003-116	T2003-116	4.0						HEATSLEEVE M2650-20 CRINKLE-SOFT STRATOFLEx
D2003-120	T2003-120	4.0						HEATSLEEVE M2650-16 CRINKLE-SOFT STRATOFLEx
D2003-14	T2003-14	4.0						HEATSLEEVE M2650-14 CRINKLE-SOFT STRATOFLEx
D2003-16	T2003-16	4.0						HEATSLEEVE M2650-16 CRINKLE-SOFT STRATOFLEx
D2003-205	T2003-205	9.75	9.60			2	2	TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W
D2003-207	T2003-207	3.75	3.75			2	2	TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 39604

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTISSUED
COPY

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2003
DATE		TITLE 206 CABIN HEATER TUBE ASSEMBLIES NTS

RELEASED

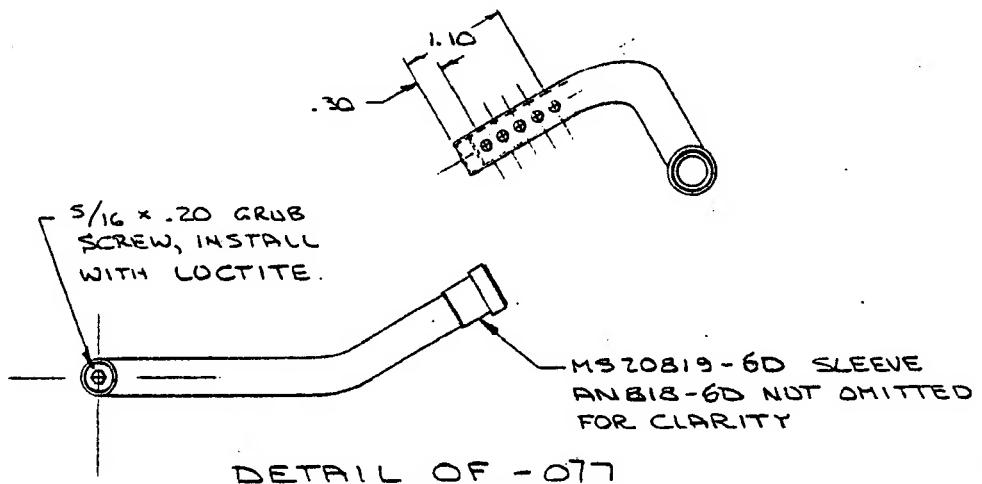
99.06.04 RE

Notes:

- (1) USE STRATOFLEX M2650-6 CRINKLE-SOFT HEATSLEEVE.
- (2) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (3) TUBES TO BE FLARED 30° TO MATE WITH FITTINGS MADE TO MS33514.
- (4) ENSURE SEAMLESS TUBING IS USED.
- (5) INSTALL HEATSLEEVE OVER ALL TUBES WITH A DESIGNATED LENGTH OF HEATSLEEVE PER THE PARTS LIST.
- (6) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (7) 0.049 WALL THICKNESS CRES TUBING MAY BE SUBSTITUTED WHEN 0.035 IS NOT AVAILABLE.
- (8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

UNDER REVIEW100.08.21 CB
Some flat lengths
not wrong

100.08.02



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39644

W/O:		WORK ORDER CHANGES					
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